



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-591-113
Job Sheet 168874



Part No: D350-591-113

Job Qty: 6 ea

Part Name: Heli-Access Step, Short, High Gear



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/23/17

Job Tracking No:

Due Date: 12/10/17

Created By: Linda Lacelle

Type: SOLD

Description:

Customer: Airbus Helicopters - Marignane (CEURO24)

Aéroport International De Marseille Cedex Marignane Marseille, , 13725 France ph:+33 4 42 85 85 85 fx:+33 4 42 85 83 00.

Note: DWG DSI 9525 REV A, D2310 REV D IPP Rev:H 04.11.09 Reformat KJ/JLM IPP Rev:E as per ECN10-586 10.06.18 DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		12/8/17	0.00	0.00	Start Up Large Fab-2		DC 2017-12-13
110	Large Fab	6 pcs		12/8/17	0.00	12.00	Large Fab 8		SLA 17/12/13
120	QC	6 pcs		12/8/17	0.00	0.00	QC9		CPC
140	QC	6 pcs		12/8/17	0.00	0.00	QC5		CPC
160	HandFinish	6 pcs		12/8/17	0.00	1.33	HandFinish1		BEB 17/12/14
170	Large Fab	6 pcs		12/9/17	0.00	6.19	Large Fab 2		CE 17/12/14
180	QC	6 pcs		12/9/17	0.00	0.00	QC10		38 38
190	QC	6 pcs		12/9/17	0.00	0.00	QC5		38 38
200	HandFinish	6 pcs		12/9/17	0.00	1.33	HandFinish1		BEB 17/12/16
210	Powdercoat	6 pcs		12/9/17	0.00	1.23	Powdercoat1		BR 17-12-20
220	HandFinish	6 pcs		12/10/17	0.00	1.33	HandFinish3		BEB 17/12/21
230	QC	6 pcs		12/10/17	0.00	0.00	QC3		17/12/21
240	Packaging	6 pcs		12/10/17	0.00	0.00	Packaging1		
250	QC	6 pcs		12/10/17	0.00	0.00	QC4		
255	DC	6 pcs		12/10/17	0.00	0.00	DC		
260	Packaging	6 pcs		12/10/17	0.00	0.00	Packaging3		
270	QC21-FG	6 Ea		12/10/17	0.00	0.00	QC21		

Part Op 110 - 1- Cut D2244 extrusion to 62.00" long as per Dwg D2310 2- Drill extrusion as per Dwg D2310 using drill Jig DT8230
Descriptions: 3- OPEN HOLE FOR BUSHING TO SIZE AS PER DWG AND C'SINK. 4- Weld Fwd end cap and bushing as per Dwg D2310 A/R AL ROD Batch: B136158 5- Grind end cap and bottom bushing welds flush 6- Machine top weld on bushing flush as per dwg.

170 - 1-Rivet as per Dwg D2310 3-Weld Aft end cap as per Dwg D2310 A/R AL ROD Batch: B137078 4- Grind end cap welds flush

210 - START TIME: 3:45 FINISH TIME: 4:15 OJT: 3200 M138467.

220 - ***Install Dart labels after wing walk***

230 - ***Install Dart labels after wing walk***

255 - Photocopy bluefile & type labels per PPP D350-591-113 CHG005

260 - Identify and pack for shipping as per PPP D350-591-113

wing walk M138711.

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5021515x6

Job Allocations						
Operation	Component Part	Required	Inventory	Allocated	Std Qty	
90-Start up Operation	D2244-116 3014552	6	105	0	0	
	D2275 5016564	6	0	0	0	
	D2673-34 5016496	12	15	0	0	
	D2582 5017704	6	7	0	0	
170-Large Fab	MS20600-AD4W3 166018	96	177	0	0	
240-Packaging	K591-113 500552	6	0	0	0	
Part Specifications						
Specifications could not be found.						

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DART
AEROSPACE
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Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Heli - Access Step, Short, High Gear

PART NO: D350 - 591 - 113
Revision:
Operation: Start up Operation
Change No:

Mfg Date: 12/13/17

Job No: 168874

Change Record

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Part Number: D350-591-113 (K591-113 PRODUCTION KIT)

Description: HELI-ACCESS STEP, HIGH SKID, SHORT STEP

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